

Work Order ID 92434

92434

Page 1

October-30-12 1:00:22 PM

Item ID: D4410-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head

Start Date: 10/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-13

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4410	B

100 Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 5.00"

D.A 12/11/03

4

φ

DA
08
9-09

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB078

FOLIO REV: 4A

DWG REV: B

DO NOT BUFF OR POLISH PART****

ONE / D.A 12/11/08

4

φ

DAS
08
9-09

DEBURR

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92434

October-30-12 1:00:22 PM

92434

Page 2

Item ID: D4410-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head
 Start Date: 10/29/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/16/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>OK 12/11/07</i> <i>B-A 12/11/08</i>		<i>4</i>	<i>0</i>		<i>DAS</i> <i>08</i> <i>9-08</i>
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>RP 2.11.9</i>		<i>4</i>	<i>1</i>		<i>DAS</i> <i>04</i> <i>9-08</i>
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>8T157</i> Memo	0.00 0.00				<i>4X</i>			<i>SP</i> <i>12-</i>

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:33%;">Skid-tube <input type="checkbox"/></td> <td style="width:33%;">Crosstube <input type="checkbox"/></td> <td style="width:33%;">Water Jet <input type="checkbox"/></td> <td style="width:33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92434

92434

Page 3

October-30-12 1:00:22 PM

Item ID: D4410-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Collective Head

Start Date: 10/29/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00


150

QC

Memo

0.00

Quality Control

12/11/13 
12-11-09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

October-30-12 1:00:21 PM

Page 1

Work Order ID: 92434

Parent Item: D4410-1

Parent Item Name: Co-Pilot Collective Head

Start Date: 10/29/12

Required Date: 11/16/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11/11/16 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B4.500X4.500		Purchased	No			100	f	4.0260	0.42	1.7684212		12/11/03	
6061-T6 Aluminum Bar 4.500" X 4.500"													

Location

Loc Qty

Loc Code

MAT004

4.026

→ 119581

4.026

1.7684 ft

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

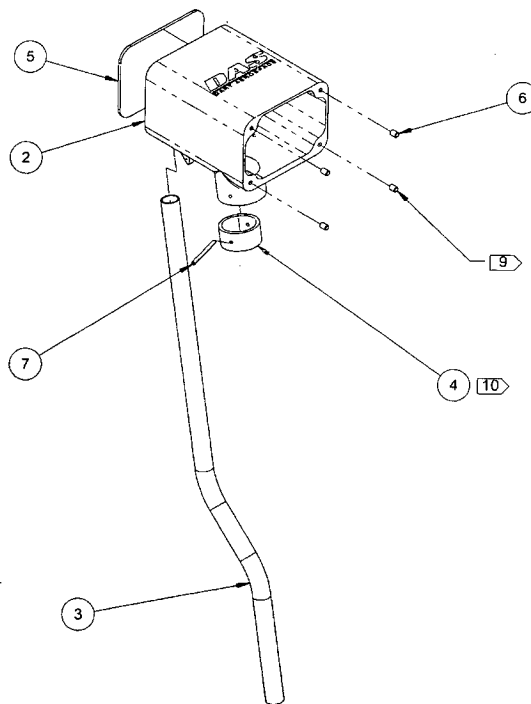
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
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Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

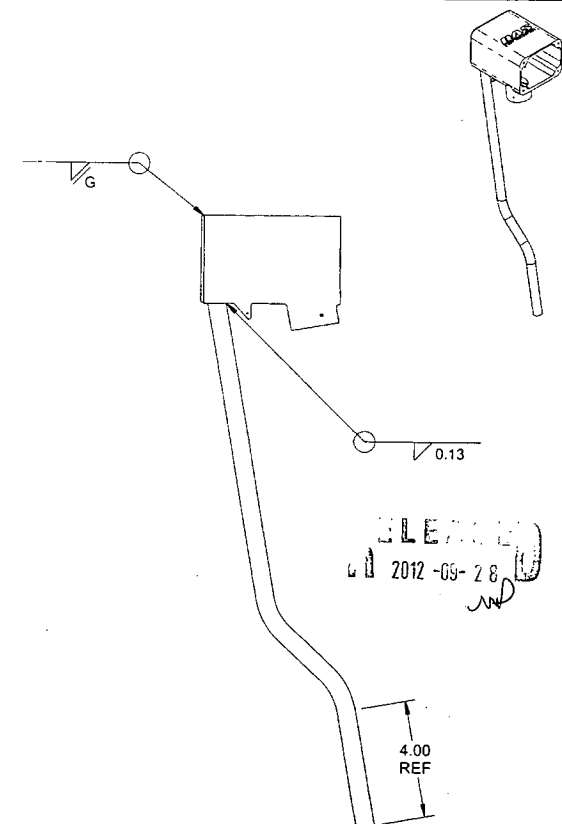
FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171539	PIN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 92434 MLJ
12-10-31



D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)



**D4410-041 WELDING DETAIL
(-041 SHOWN, -043/-045 SIMILAR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

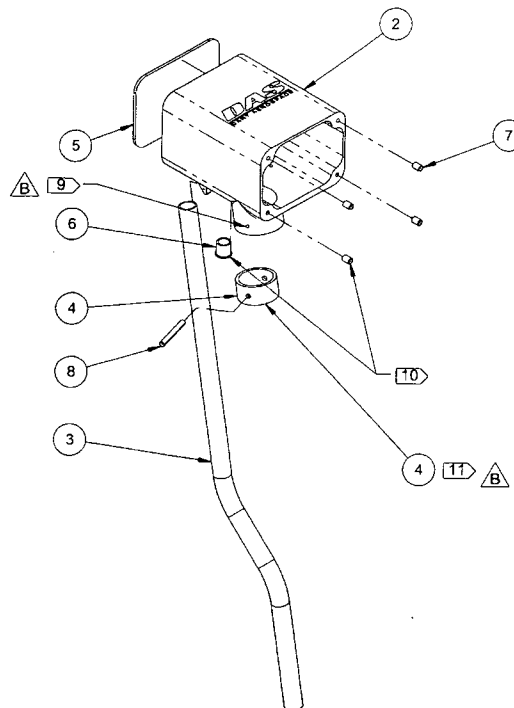
B	ADD C-BORE, ZN A4-2. ENLARGE HOLES, ZN C5-3 & B8-3. UPDATE LOGO. ADD -043/-11/-13/-15. ROTATE HOLE, ZN C5-2. INCREASE -7 DIAMETER, ZN C1-6. REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1.	DC	12.07.30
A	NEW ISSUE	DC	11.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	12.07.30		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4410** REV. B
SHEET 1 OF 12
TITLE **CO-PILOT COLLECTIVE HEAD** SCALE NTS

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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1	MS171599	PIN



NOTES:

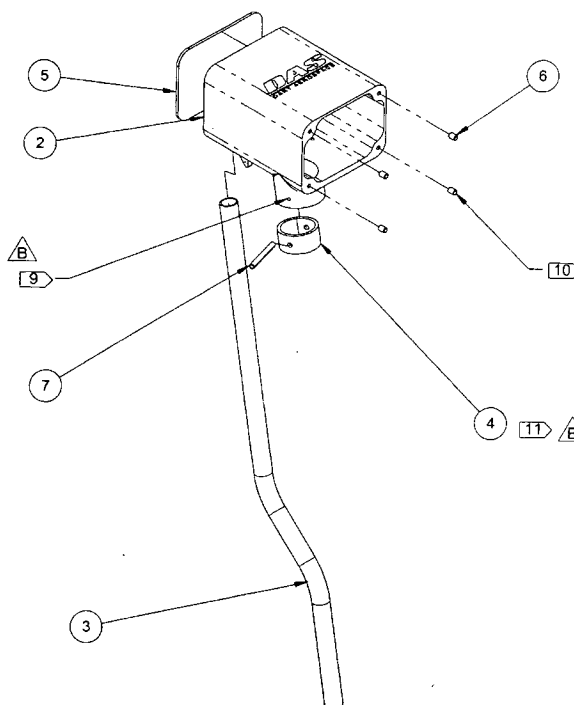
- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 2 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD NTS	
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171599	PIN

92434

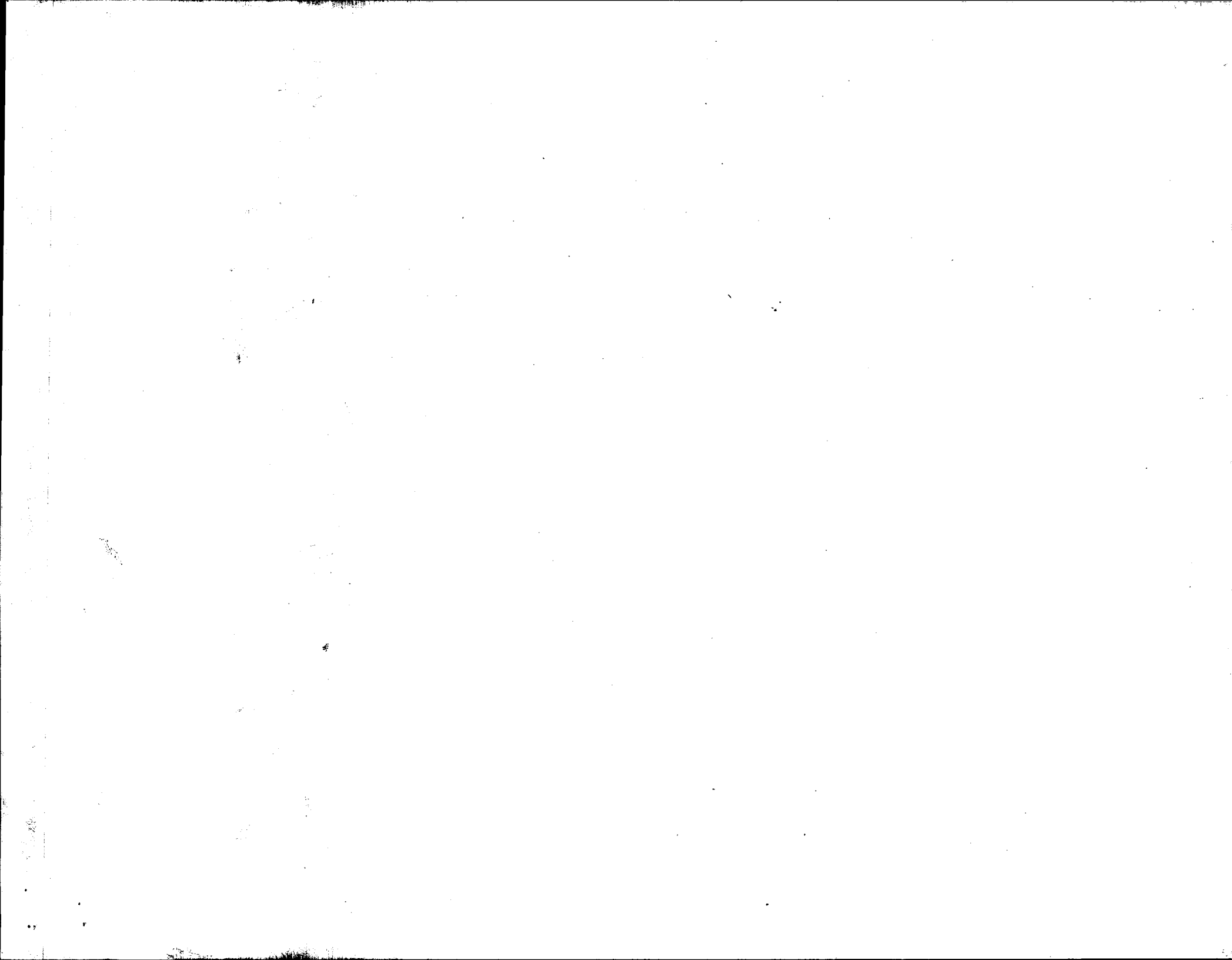


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #16)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

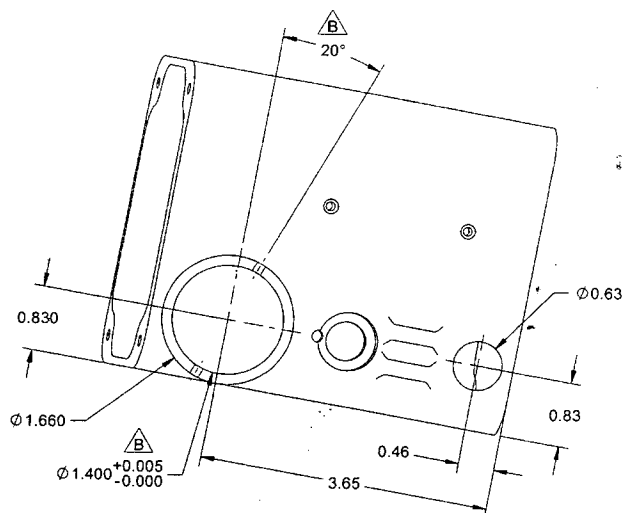
D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	ES	DRAWING NO.	REV. B
MFG. APPR.	21	D4410	SHEET 3 OF 12
APPROVED	149	TITLE	SCALE
DE APPR.	44	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

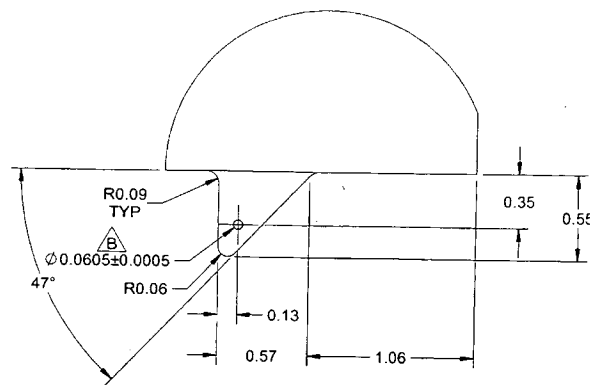


DESIGN	<i>PL</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4410 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. B
DRAWN	<i>PL</i>		SHEET 4 OF 12
CHECKED	<i>PL</i>		SCALE
MFG. APPR.	<i>PL</i>		NTS
APPROVED	<i>PL</i>		
DE APPR.	<i>PL</i>		
DATE		12.07.30	

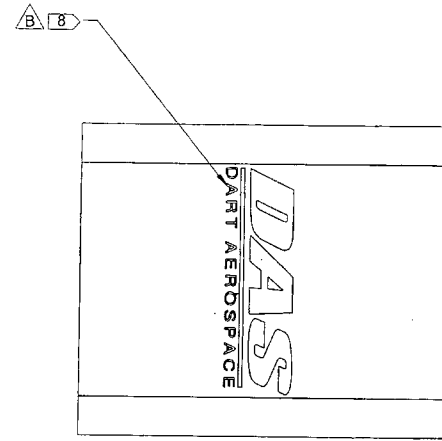
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VIEW A-A
C5-4



DETAIL B
C4-4



VIEW C-C
D4-4

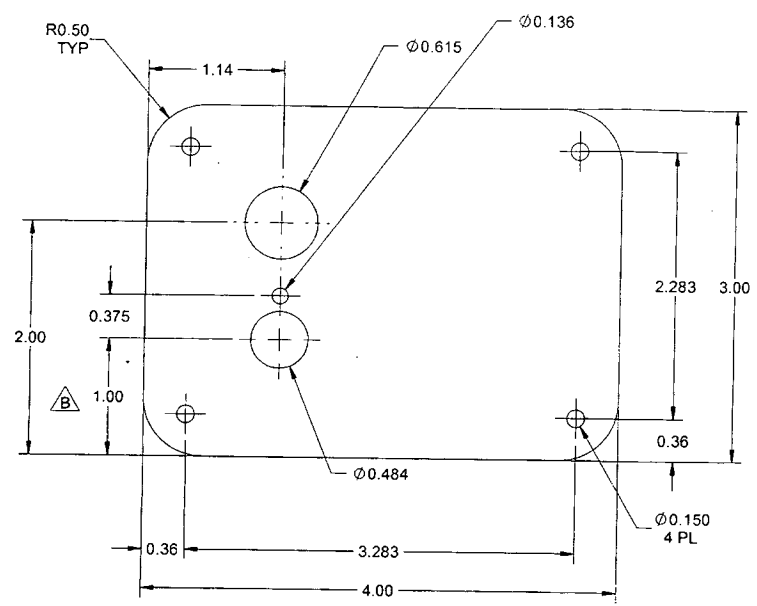
**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

RELEASED
2012-09-28

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

DESIGN	DC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	21	D4410	SHEET 5 OF 12
APPROVED	140	TITLE	SCALE
DE APPR.	11	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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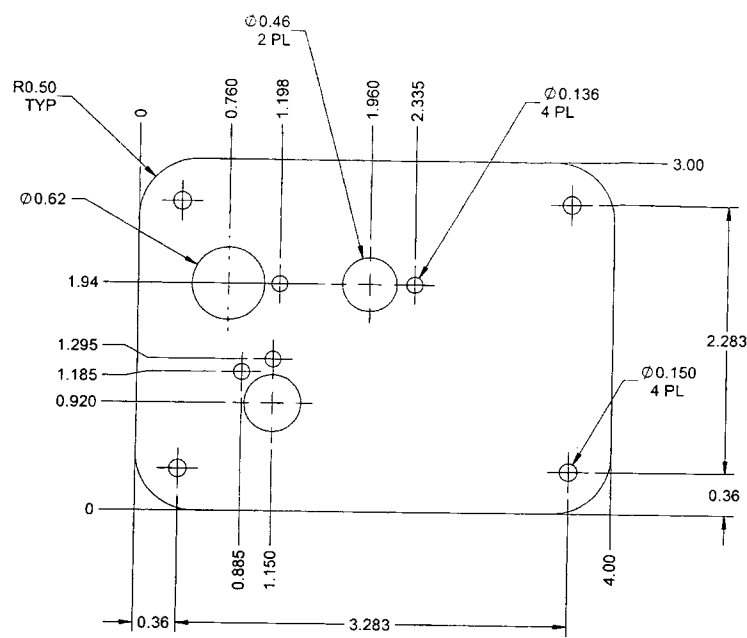
D4410-3 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	2/1	D4410	SHEET 6 OF 12
APPROVED	1/10	TITLE	SCALE
DE APPR.	1/1	CO-PILOT COLLECTIVE HEAD	NTS
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D4410-5 FACE PLATE

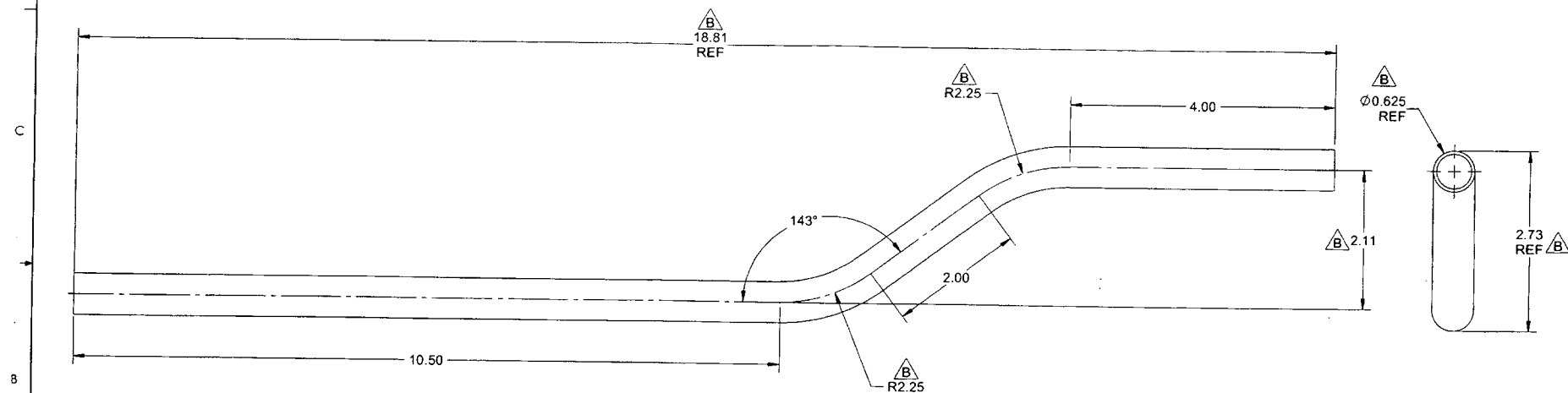
RELEASED
2012-09-28

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	SA	D4410	SHEET 7 OF 12
APPROVED	MD	TITLE	SCALE
DE APPR.	SA	CO-PILOT COLLECTIVE HEAD NTS	
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
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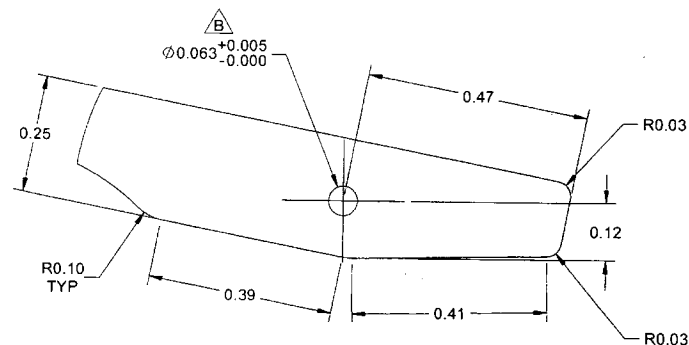
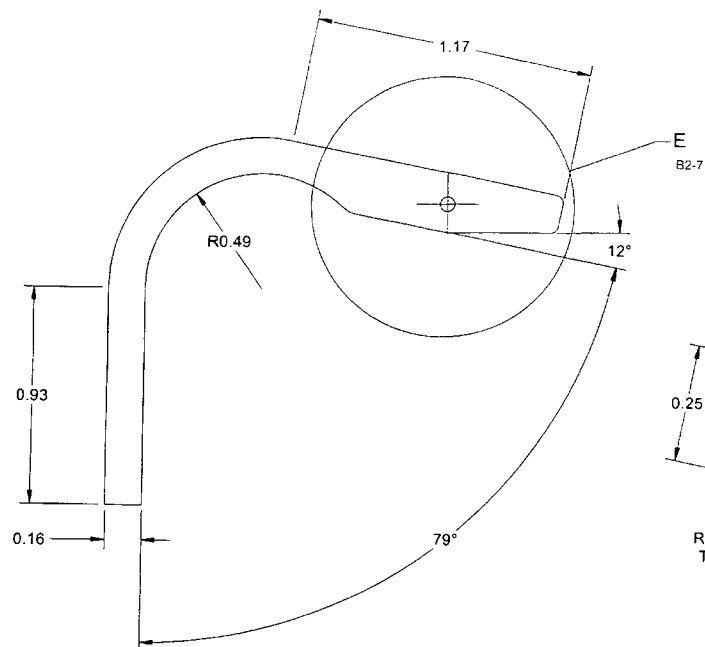
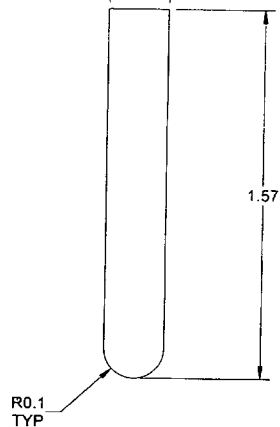
**D4410-7 CONDUIT****NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T60.625W.050 $\triangle B$
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

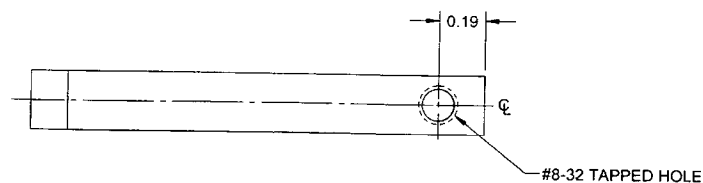
DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	2/1	D4410	SHEET 8 OF 12
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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$\triangle B$
+0.000
0.250
-0.005
REF



DETAIL E
D4-7



D4410-9 TRIGGER

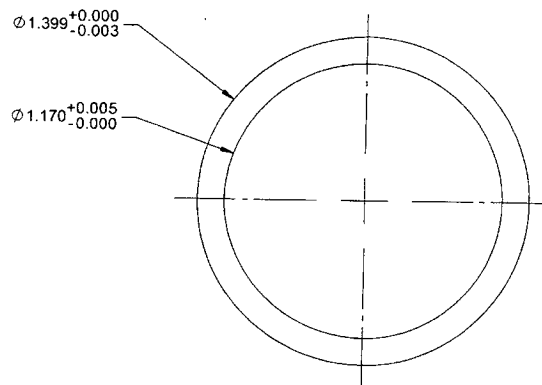
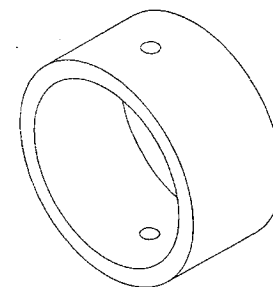
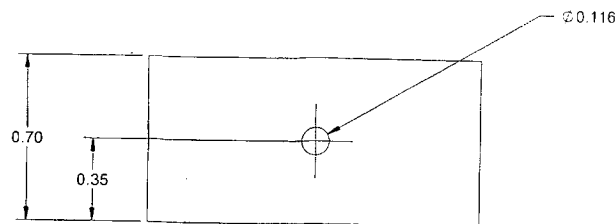
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED
2012-09-28

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D4410	SHEET 9 OF 12
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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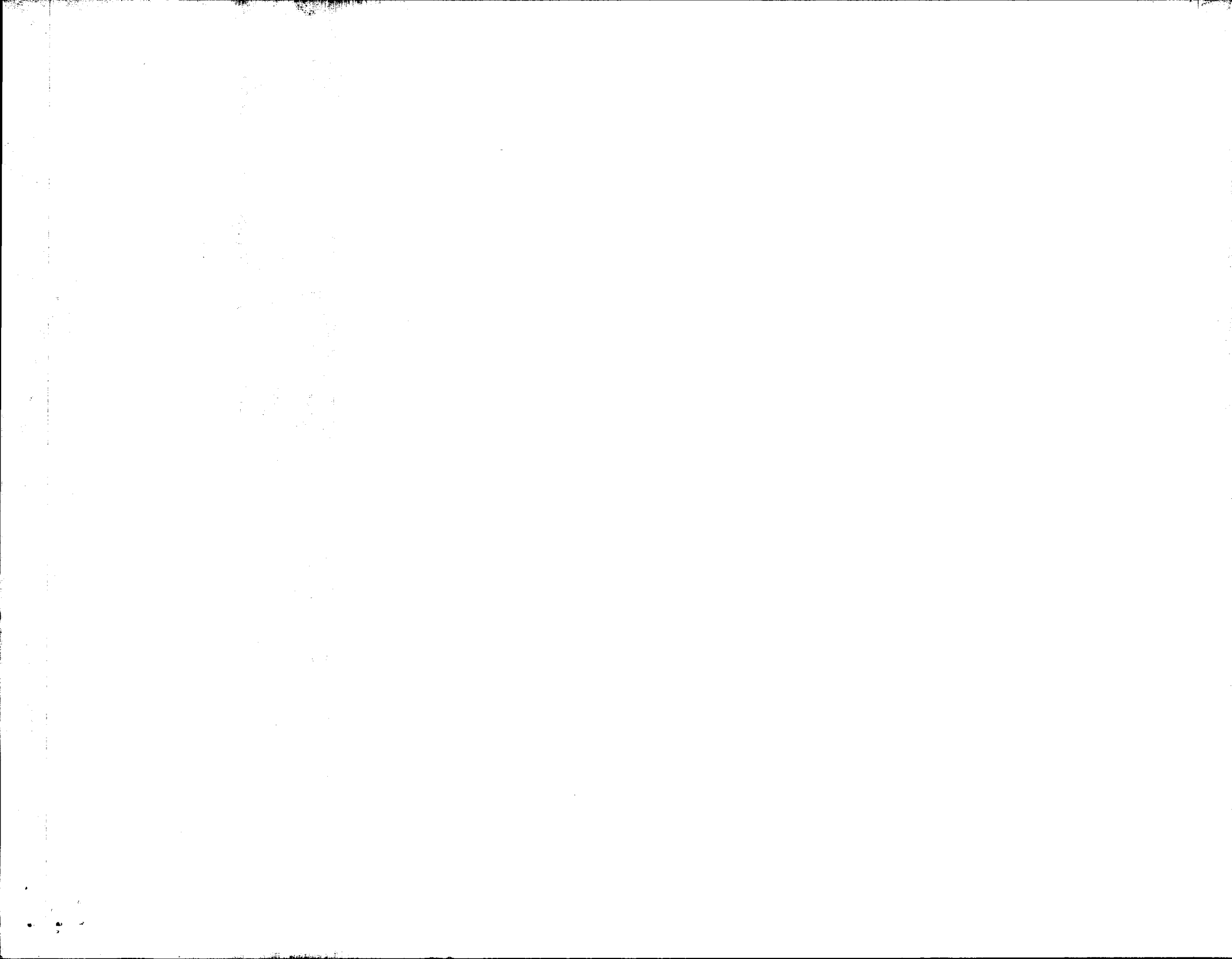
D4410-11 205 SHIM

RELEASED
2012-05-23
and

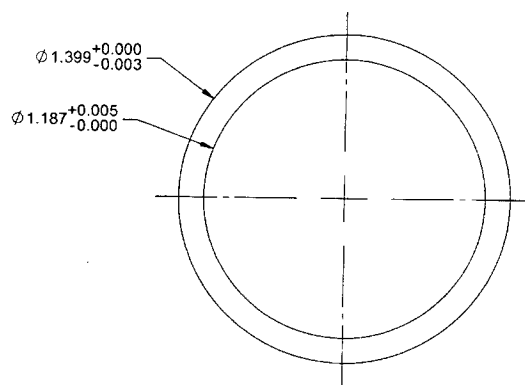
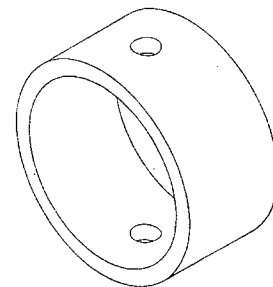
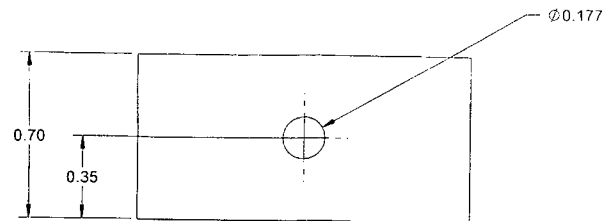
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	ES	DRAWING NO.	REV. B
MFG. APPR.	21	D4410	SHEET 10 OF 12
APPROVED	142	TITLE	SCALE
DE APPR.	142	CO-PILOT COLLECTIVE HEAD	NTS
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D4410-13 212 SHIM

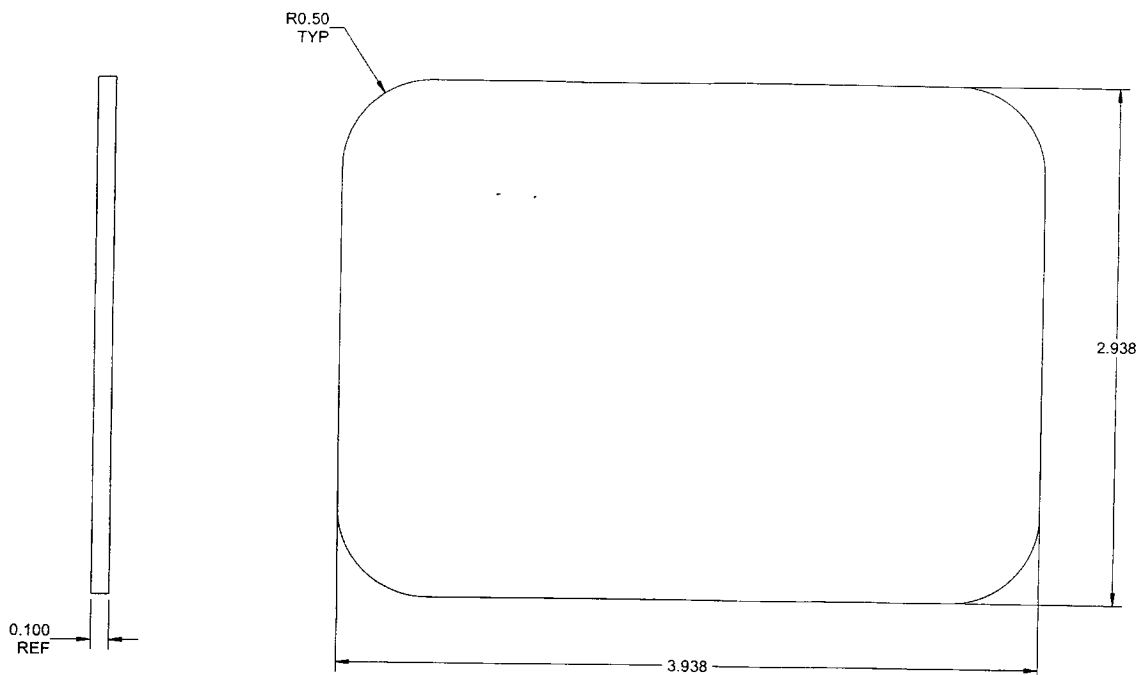
RELEASED
2012-09-28
WMP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	21	D4410	SHEET 11 OF 12
APPROVED	14	TITLE	SCALE
DE APPR.	14	CO-PILOT COLLECTIVE HEAD	NTS
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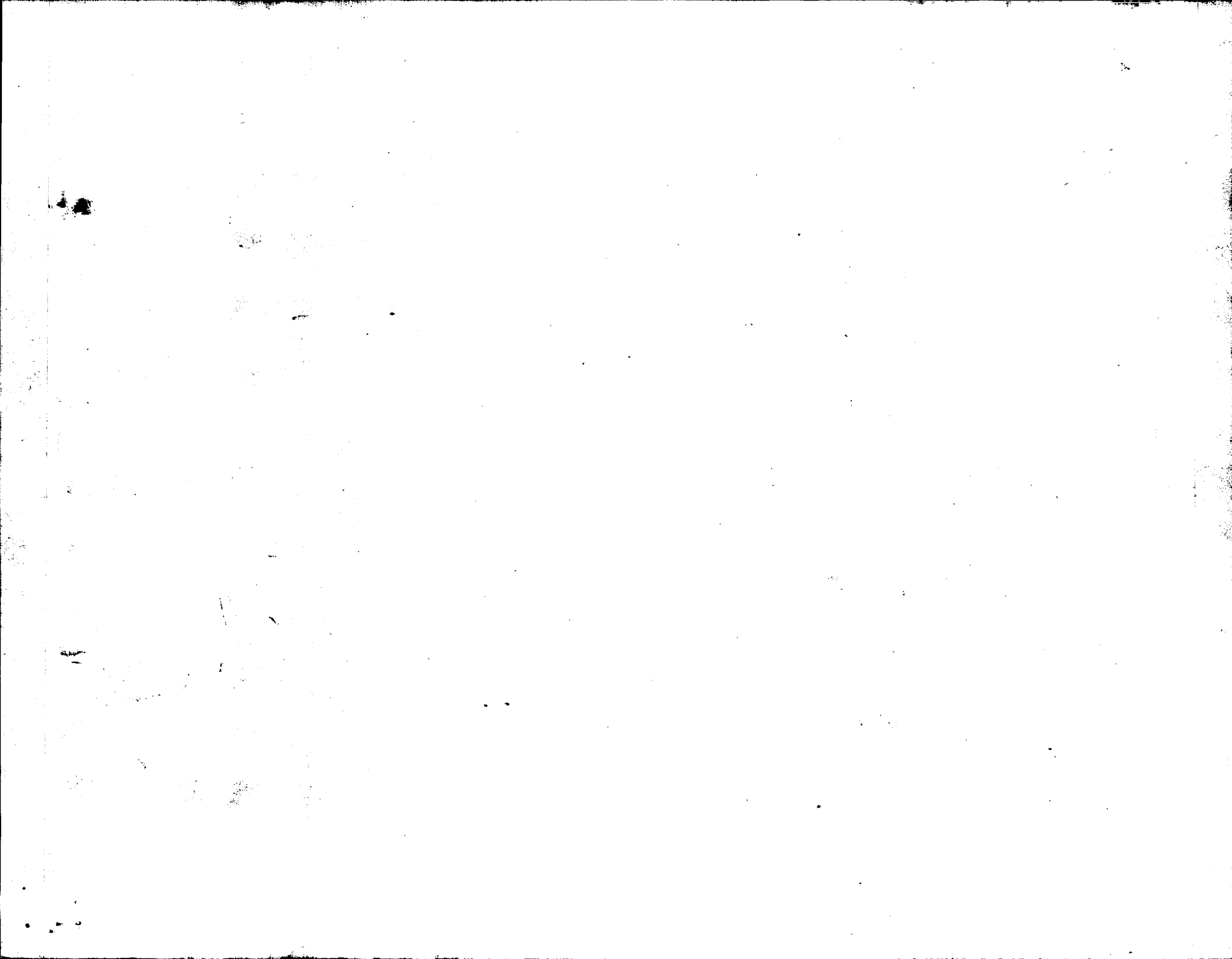
D4410-15 REAR COVER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

RELEASE
2012-09-28
JN

DESIGN	BC	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 12 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
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DART AEROSPACE LTD	Work Order: 92 434
Description: C.O-PILOT COLLECTIVE HEAD	Part Number: D4410-1
Inspection Dwg: D4410 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	$\pm .030$	4.002	—		Vern	ML-DL
.65	$\pm .030$.650	—		"	"
$\phi .150$	$\pm .005$	$\phi .152$	—		"	"
1.69	$\pm .030$	1.690	—		"	"
.65	$\pm .030$.650	—		"	"
.36	$\pm .030$.360	—		"	"
3.283	$\pm .005$	3.282	—		"	"
R.13	$\pm .030$	R.125	—		R-G	"
.25	$\pm .030$.253	—		Vern	ML-06
.600 \downarrow	$\pm .010$.610	—		"	"
.36	$\pm .030$.360	—		"	"
2.283	$\pm .085$	2.282	—		"	"
3.00	$\pm .030$	2.999	—		Vern	GA-01
4.70	$\pm .030$	4.697	—		Vern	ML-DL
10°	$\pm 1/2^\circ$	10°	—		C-Agure	ML-LBB
$\phi .116$	$\pm .004$	$\phi .118$	✓		Vern	GA-01
.35	$\pm .030$	0.350	✓		"	"
.92	$\pm .030$.917	—		Vern	ML-DL
4.35	$\pm .030$	4.355	—		"	"
2.00	$\pm .030$	1.999	—		"	"
1.782	$\pm .005$	1.783	—		"	"
1.50	$\pm .030$	1.5005	—		"	"
$\phi .115$	$\pm .004$	$\phi .117$	—		"	"

Measured by: <i>anf</i>	Audited by: <i>2P</i> (DAS) 04 2-82	Preliminary Approval:
Date: 12/11/07	Date: 12.11.9	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD	Work Order: 92434
Description: CD-PILDT COLLECTIVE HEAD	Part Number: D4410-1
Inspection Dwg: D4410 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.188 X 106°	±.010 X ± 1/2°	Ø0.194 X 100°	✓		Vern	GA-01
.83	±.030	0.833	✓		H-G	31006
Ø.1160	±.005 ±.001	Ø0.1161	✓		Vern	GA-01
Ø.750	±.010	Ø0.750	✓		"	"
.150 ↓	±.010	0.149	✓		D-6	GA-08
2.16	±.030	2.159	✓		H-G	31006
.50	±.030	0.505	✓		"	"
.20	±.030	0.201	✓		Vern	GA-01
.254	±.005 ±.001	0.254	✓		"	"
Ø.500	±.006 ±.001	Ø0.501	✓		"	"
.830	±.005	0.833	✓		H-G	31006
Ø1.660	±.010	Ø1.5585	✓		Mic	GA-02
Ø1.400	±.005 ±.001	Ø1.4004	✓		Mic	GA-02
3.65	±.030	3.650	✓		H-G	31006
.46	±.030	0.456	✓		"	"
.83	±.030	0.833	✓		"	"
Ø.63	±.030	Ø0.629	✓		Vern	GA-01
20°	± 1/2°	20°	✓		C-square	ML-CBB
.35	±.030	0.345	✓		H-G	31006
.55	±.030	0.550	✓		"	"
1.06	±.030	1.055	✓		Vern	GA-01
.13	±.030	0.126	✓		H-G	31006
.57	±.030	0.590	✓		Vern	GA-01

Measured by: 08 DAS	Audited by: DP DAS	Preliminary Approval:
Date: 12/11/08	Date: 12.11.9	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

